

Work Order ID 77897

77897

Page 1

December-22-11 11:42:52 AM

Item ID: D412-704-041

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pedal Assembly (205/212/214/412)

Start Date: 22/12/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: M.L.J.

Date: 11/12/22

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D412-704-041	Rev A

100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble pedal as per Dwg D412-704-041 Tighten & Torque Bolts as per Dwg D412-704-041								

Signature 12/29/22 @

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

Signature 12/29/22

(42)

120	Pick Kit	0.00							
120									
Packaging	Memo	0.00							
Packaging									

Signature

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77897

77897

Page 2

December-22-11 11:42:52 AM

Item ID: D412-704-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pedal Assembly (205/212/214/412)
 Start Date: 22/12/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC4- 100% Inspect kits for completeness	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>23B</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

12/4/2011
 12-03-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

December-22-11 11:42:56 AM

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Work Order ID: 77897

77897

Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:B05.01.28Removed hardware on Step 2; Added Figures 1-3KJ/RF
 IPP Rev:C06.03.08 Re-format EC
 IPP Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM
 IPP Rev:E 07.05.02 Reformat EC
 IPP Rev:F 08-10-08 as per revB DD veriified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A *AN3-10A* Bolt		Purchased	No			100	Each	137.0000	1	2			
										**	EB 12/03/29		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				95			2		
				119084				95					
				ST351				42					
				117795				26					
				119128				16					
AN315-4R *AN315-4R* Nut		Purchased	No			100	Each	39.0000	1	2			
										**	EB 12/03/29		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST344				39			2		
				17566				39					
AN4-10A *AN4-10A* Bolt		Purchased	No			100	Each	120.0000	1	2			
										**	EB 12/03/29		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST356				120			2		
				117619				120					

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 77897

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 2.00

Required Qty: 2.00

AN4-12A Purchased No

100 Each 176.0000 2 4

AN4-12A

Bolt

**

EB12/03/29

Location

Loc Qty

Loc Code

ST357

176

115422

4

117508

22

118628

100

119775

50

4

AN4-13A Purchased No

100 Each 738.0000 1 2

AN4-13A

Bolt

**

EB12/03/29

Location

Loc Qty

Loc Code

ST357

738

118078

17

118838

121

119449

500

119798

100

2

AN960JD10 NAS1149D0363J Purchased No

100 Each 0.0000 5 10

AN960.ID10

Washer

**

EB12/03/29

AN960JD416 NAS1149D0463J Purchased No

100 Each 0.0000 11 22

AN960.ID416

Washer

**

EB12/03/29

AN960JD416L NAS1149D0416J Purchased No

100 Each 8.0000 3

AN960.ID416I

Washer

**

EB12/03/29

Location

Loc Qty

Loc Code

FP002

8

110153

8

December-22-11 11:42:56 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod.Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 77897

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 2.00

Required Qty: 2.00

J D3204-041

Manufactured No

100 Each 0.0000

1 2

D3204-041

Release Pedal Assembly

D3205-1

Manufactured No

100 Each 0.0000

1 2

D3205-1

Pedal Bracket

A D3205-3

Manufactured No

100 Each 17.0000

1 2

D3205-3

Back Plate

Location

Loc Qty

Loc Code

GA

17

69626

7

70285

10

D3206-1

Manufactured No

100 Each 15.0000

1 2

D3206-1

Pedal Arm

Location

Loc Qty

Loc Code

GA

15

73469

15

D3209-041

Manufactured No

100 Each 9.0000

1 2

D3209-041

Bracket Assembly

Location

Loc Qty

Loc Code

GA

9

71653

9

EP 12/03/29
EP 12/03/29
EP 12/03/29

B82060
EP 12/03/29

2
EP 12/03/29

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 77897

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

100

Each

6,837.000

1

2

MS21042I 3

Nut

**

EP 12/23/29

Location

Loc Qty

Loc Code

ST300

6837

117441

16

117885

32

118451

5

118927

3

119017

5988

119075

793

2

MS21042L4

Purchased

No

100

Each

8,927.000

5

10

MS21042I 4

Nut

**

EP 12/23/29

Location

Loc Qty

Loc Code

ST300

8927

117441

51

117601

342

118451

133

119017

3401

119075

5000

10

MS24694-S102

Purchased

No

100

Each

34.0000

1

2

MS24694-S102

Screw

**

EP 12/23/29

Location

Loc Qty

Loc Code

ST289A

34

114382

34

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 77897

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 2.00

Required Qty: 2.00

MS9519-10

Purchased

No

100

Each

22.0000

1

2

MS9519-10

Bolt

**

Ep 12/03/29

Location

Loc Qty

Loc Code

ST296

22

100290

22

AN3-6A

Purchased

No

120

Each

196.0000

2

4

AN3-6A

Bolt

**

120498 JB

Location

Loc Qty

Loc Code

ST351

196

117441

146

119775

50

AN960JD10L

NAS1149D0332J

Purchased

No

120

Each

0.0000

4

8

***AN960.ID10I ***

Washer

MS21042L3

Purchased

No

120

Each

6,837.000

2

4

MS21042I 3

Nut

**

120644 JB

Location

Loc Qty

Loc Code

ST300

6837

117441

16

117885

32

118451

5

118927

3

119017

5988

119075

793

119017

12/03/30

December-22-11 11:42:56 AM

Shop Packet Print

Page 5

Dart Aerospace Ltd

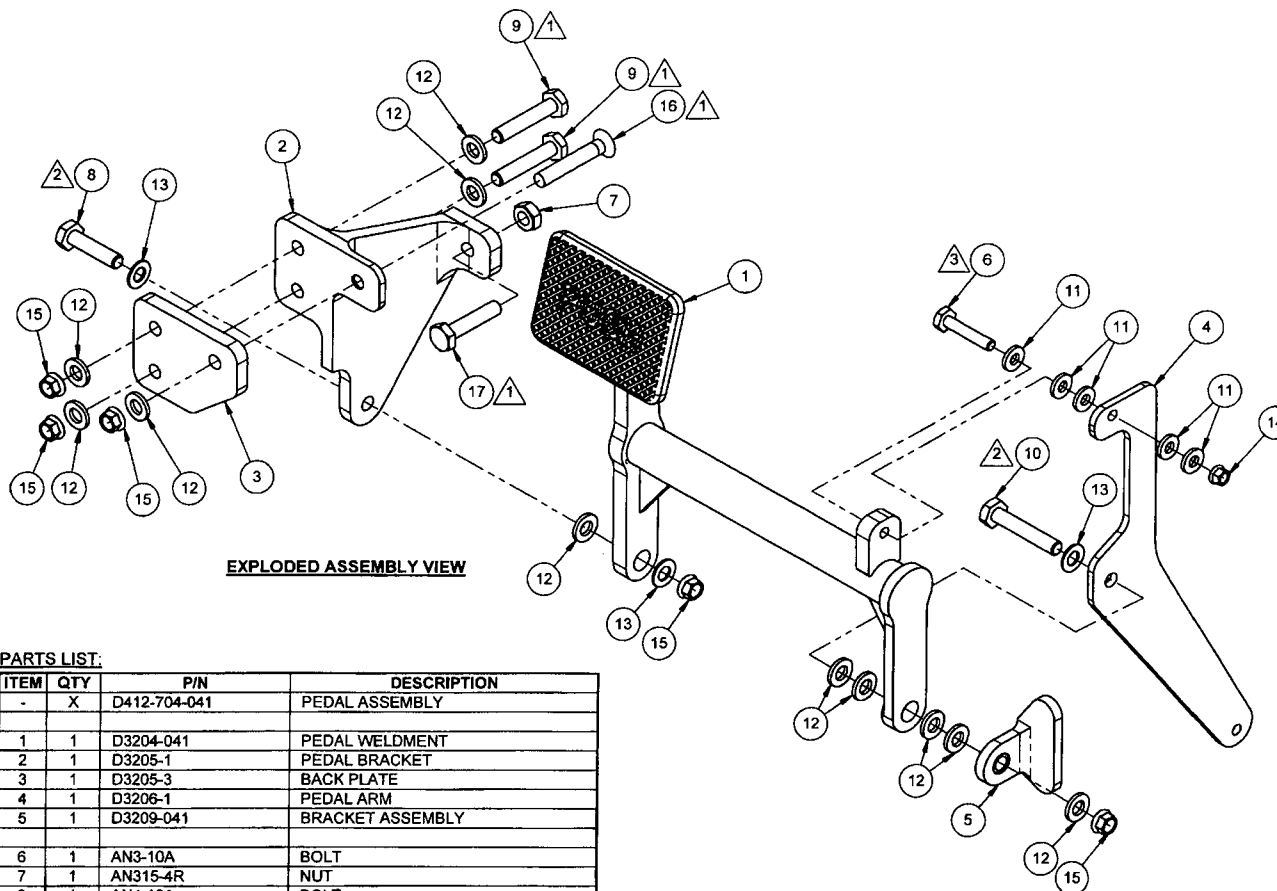
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



EXPLODED ASSEMBLY VIEW

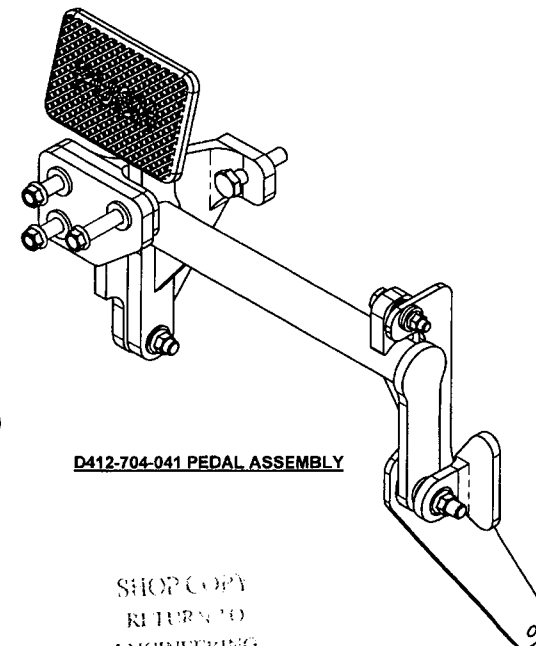
PARTS LIST:

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

NOTES:

- 1 INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2 TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3 TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).



D412-704-041 PEDAL ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **778974.6.5**
11/12/22

RELEASED

07.01.23

A	07.01.23	NEW ISSUE	DESCRIPTION
REV	DATE		
DESIGN	DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
C.B.	C.B.		
CHECKED	APPROVED		DRAWING NO. D412-704-041
C.E.			REV. A SHEET 1 OF 1
DATE	07.01.23	TITLE	SCALE
		PEDAL ASSEMBLY	1:2

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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